

# Work Order ID 80892-

Friday, March 02, 2012 2:57:55 PM

\*80892\*

Page 1

Item ID: D4571-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Tail Rotor Disabling

Start Date: 3/12/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 3/23/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan: *UMF*

Date: *12-03-02* Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4571

A

100

Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

*SS 12/03/02*

*① TF 12-03-29*

*Sc 12/03/29*

*④*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 80892**

Friday, March 02, 2012 2:57:55 PM

**\*80892\***

Page 2

Item ID: D4571-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Tail Rotor Disabling

Start Date: 3/12/2012 Start Qty: 5.00 **\*5\***

Cust Item ID:

Required Date: 3/23/2012 Req'd Qty: 5.00 **\*5\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/3/2012

MLO 12/03/2012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Friday, March 02, 2012 2:57:54 PM

Page 1

Work Order ID: 80892

Parent Item: D4571-041

Parent Item Name: Tail Rotor Disabling

Start Date: 3/12/2012

Required Date: 3/23/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV: A 12.01.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
X AN960-416 Washer	<u>NAS1149F0463P</u>	Purchased	No	120739			Each	0.0000	2	10	①	FF 12-03-29	
D3384-047 Cyclic Sock Assembly		Manufactured	No	7704			Each	9.0000		5	①	FF 12-03-29	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
				80821				6					
				ST486				3					
				77187				3	1				
HX-81 1/4"-20 SHCS 3/8" long		Purchased	No				Each	95.0000		5		①	FF 12-03-29
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				50					
				120357				50					
				ST390				45					
				114383				1					
				120773				44	1				
97395A461 Dowel Pin		Purchased	No			100	Each	9.0000	2	10		①	FF 12-03-29
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				9					
				120146				9	2				
D3373-5 Cam Lock		Manufactured	No			100	Each	63.0000	1	5		①	FF 12-03-29
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST039				12					
				78439				12	1				
				ST040				51					
				22383				51					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, March 02, 2012 2:57:55 PM

Page 2

Work Order ID: 80892

Parent Item: D4571-041

Parent Item Name: Tail Rotor Disabling

Start Date: 3/12/2012

Required Date: 3/23/2012

Start Qty: 5.00

Required Qty: 5.00

D3385-3	Manufactured	No	100	Each	78.0000	1	5
Hinge							

① FF 12-03-29

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST041	78	
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<u>22387</u>	78	
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D4571-1	Manufactured	No	100	Each	0.0000	1	5
Base							

① FF 12-03-29

D4571-3	Manufactured	No	100	Each	0.0000	1	5
Cover							

① FF 12-03-29

MS51957-41	Purchased	No	100	Each	56.0000	4	20
Screw							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST295	56	
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<u>120177</u>	56	
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① FF 12-03-29

Friday, March 02, 2012 2:57:55 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

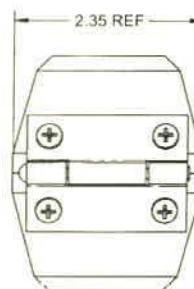
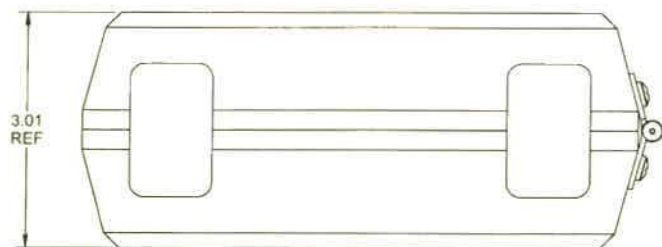
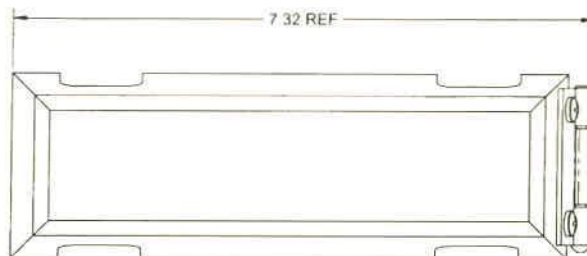
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

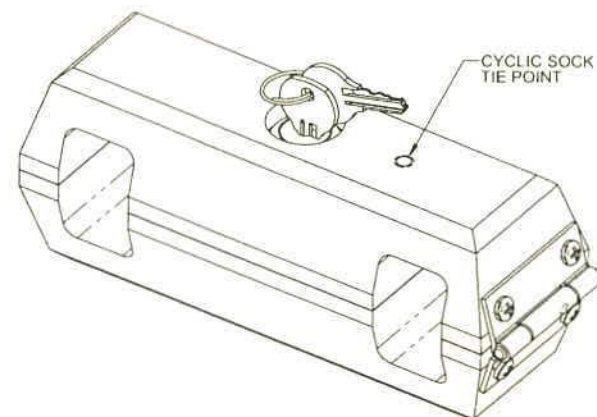
**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -051	P/N	DESCRIPTION
	X		D4571-041	TAIL ROTOR DISABLING KIT
	1	X	D4571-051	PEDAL LOCK
	1		D3384-047	CYCLIC SOCK
	1		MS 16995-47	SCREW, SKT-HD
	2		AN960-416	WASHER, FLAT
1		1	D3373-5	CAM LOCK ASSEMBLY
2		1	D3385-3	HINGE
3		1	D4571-1	BASE
4		1	D4571-3	COVER
5		4	MS51957-41	PH-HD SCREW, #8
6		2	97395A461	DOWEL PIN (MCMaster CARR)



**D4571-051 PEDAL LOCK**



Ø	ADDED CYCLIC SOCK AND RELATED HARDWARE TO BOM ADDED DIM Ø 560, DELETED DIM Ø 188 SHT 3 ADDED DIM 1 200, DELETED DIM Ø 300 SHT 4	RP	12 01 23
A	NEW ISSUE	RP	12 01 06
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	RP	D4571	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED  
2012-01-30

#80892

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

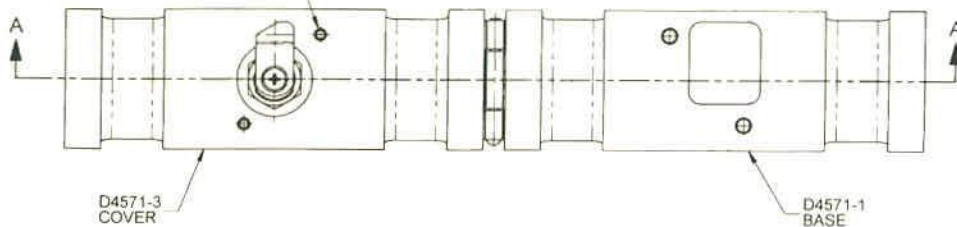
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

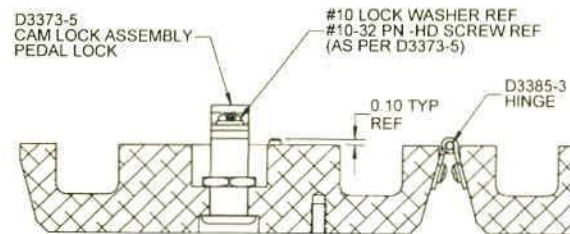
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

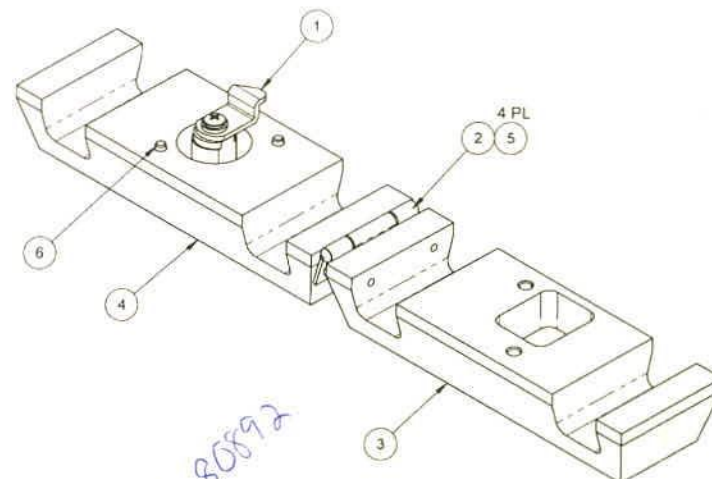
97395A461  
DOWEL PIN (MCMASTER CARR)



**D4571-051 PEDAL LOCK ASSEMBLY**



**SECTION A-A**



RELEASED  
2012-01-30

**NOTES**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO <b>D4571</b>	REV B
MFG APPR	CE		SHEET 2 OF 4
APPROVED	MP	TITLE <b>PEDAL LOCK</b>	SCALE
DE APPR	N/A		NTS
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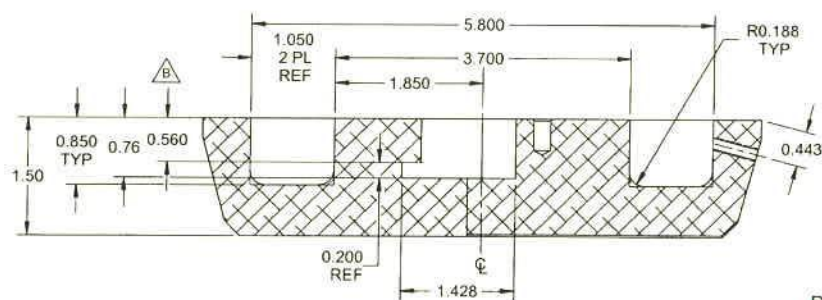
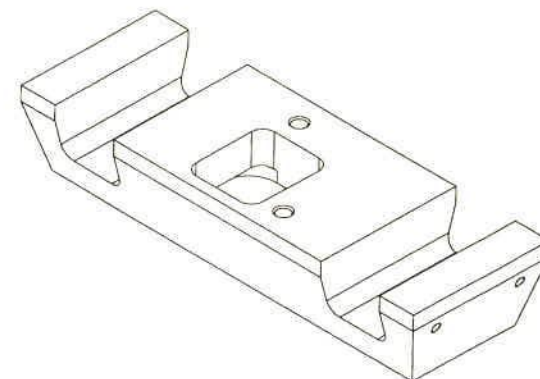
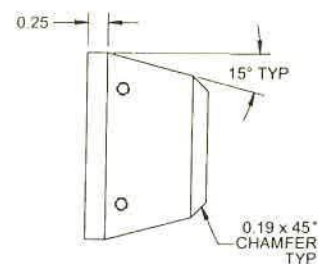
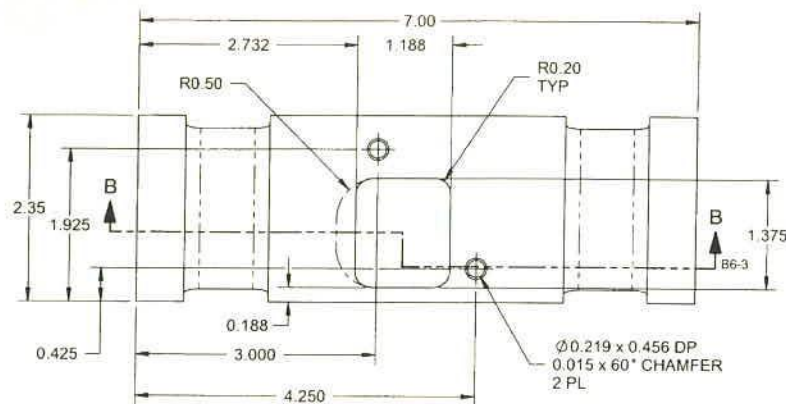
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

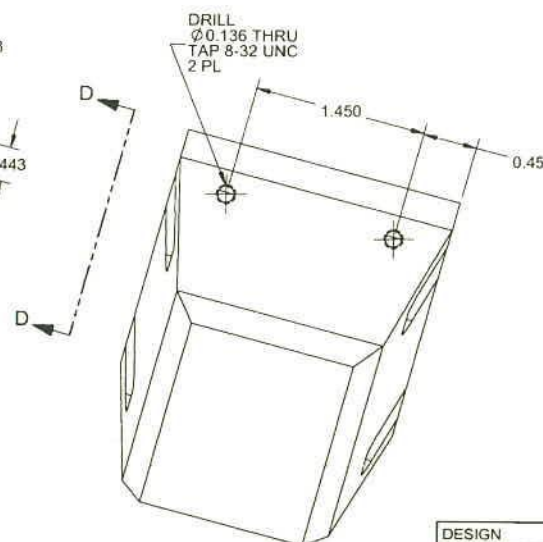
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





SECTION B-B C6-3



VIEW D-D

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

**D4571-1 BASE**

**RELEASED**  
2012-01-30

DESIGN	RP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO. <b>D4571</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE <b>PEDAL LOCK</b>	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	N/A	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.01.23		

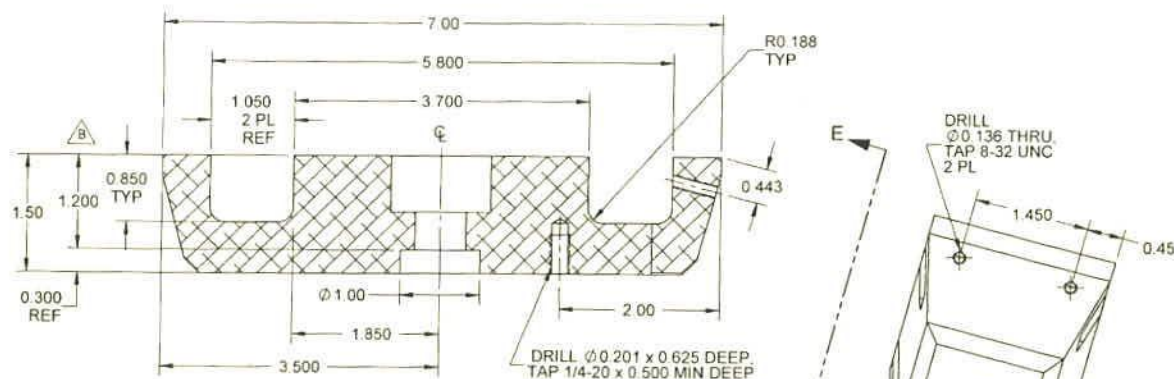
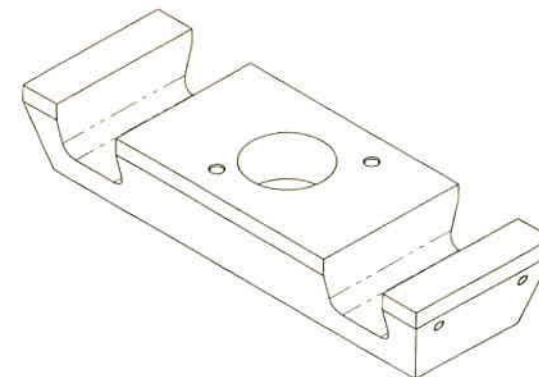
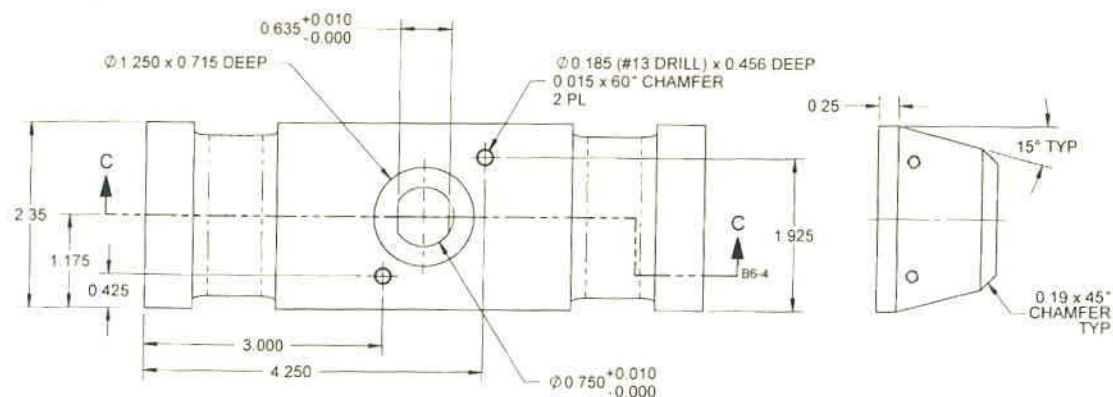
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

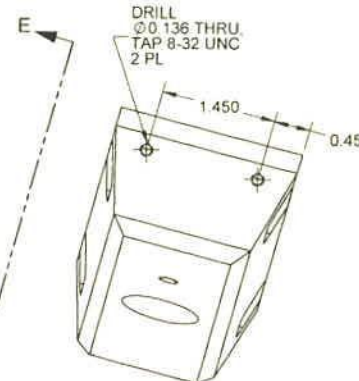
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**NOTE:** Date & initial all entries



SECTION C-C D5-4



VIEW E-E

# NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-3 COVER

RELEASED  
2012-01-30

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO	REV. B
MFG APPR.		D4571	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
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